

Work Order ID 146019

Thursday, May 12, 2016 10:08:51 AM

146019

Page 1

Item ID: D4095-051

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad Fwd

Start Date: 4/29/2016 Start Qty: 8.00

8

Cust Item ID:

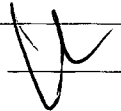
Required Date: 5/5/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	C								

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg (D4095-11)

Dwg Rev: CProg Rev: C

2-Deburr if necessary

0.00

0.24



DC 16/06/28

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.08



DC 16/06/28

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.16



DAS

38

9-89

JUN 29 2016

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Page 2

Item ID: D4095-051

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad Fwd

Start Date: 4/29/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Form as per dwg NC BRAKE	0.00			DAS 30 9-89	8			JUN 30 2016
130									
Brake NC	Memo	0.08							
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.16							
Quality Control									
150		0.00							
150									
HandFinish	Memo	0.56							
Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>134811</u>								
									DAS 41 9-89 16-7-5

Work Order ID 146019

Thursday, May 12, 2016 10:08:51 AM

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Page 3

Item ID: D4095-051 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Fwd
 Start Date: 4/29/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.08				(8)			38 9-89 JUL 06 2016
Quality Control									
170	Identify as per dwg & Stock Location <u>FP-001</u>	0.00							
170									
Packaging	Memo	0.08							
Packaging	LOCATION : FP001								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.80							
Quality Control									

SEA 7/7/16

Picklist Print

Thursday, May 12, 2016 10:08:51 AM

Page 1

Work Order ID: 146019

146019

Parent Item: D4095-051

D4095-051

Parent Item Name: Wearpad Fwd

Start Date: 4/29/2016

Required Date: 5/5/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	246.4100		1.56			

M304S16GA

304/316 Sheet .063

De-ile/Ole/28

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	75.95	
m134677	75.95	
MAT019	78.376	
m134067	0.706	
m134158	13.403	
m134399	1.067	
m134551	63.2	
TPI	134592	
m134604	92.084	

1.8

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD

D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT CENTERLINE

UNDER REVIEW

URF 16-572 ML

16.05.03

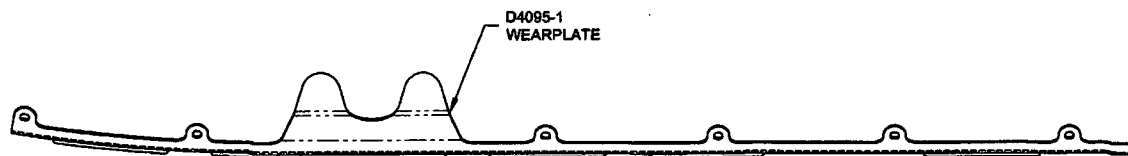
RELEASED
2016-01-11
EN 16-504

C	8259 WELD ROD WAS 2059B, 0.20 WELD THICKNESS WAS 0.25, MOVE DRAIN HOLE IN -1/3, 0.9 WAS 2.00 (TYPO B4-9), ADJUST TOL. FOR MANUFACTURABILITY, NOTE 2 NOW REF'S QSI 005 4.9, UPDATE MAT'L SPEC	CP	16.01.06
B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCK-GUARD REPLACES D4096-1/-3; ADDED D4095-6/-7 -8/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	16.01.06		

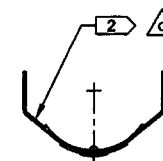
DART AEROSPACE USA, INC EUGENE, OR	
DRAWING NO. D4095	REV. C SHEET 1 OF 9
TITLE WEARPLATE	SCALE NTS
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w/o 146019

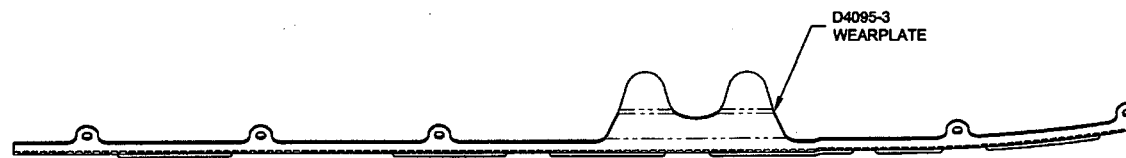
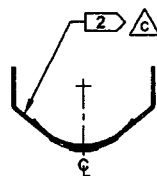
2m 16/05/06



D4095-1
WEARPLATE



D4095-041 WEARPLATE ASSEMBLY

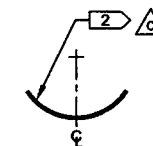


D4095-3
WEARPLATE

D4095-043 WEARPLATE ASSEMBLY



D4095-5
WEARPLATE



D4095-045 WEARPLATE ASSEMBLY

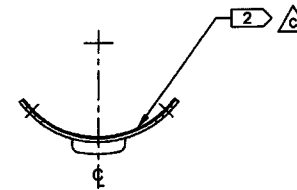
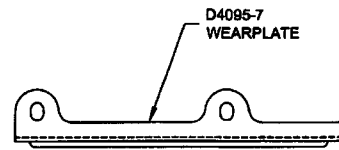
UNDER REVIEW

URF 16-572 ML

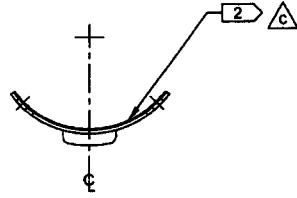
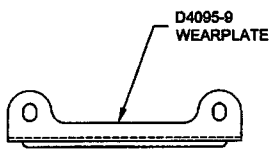
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2016-01-11

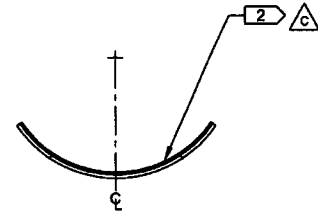
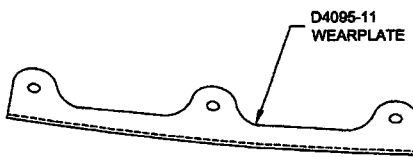
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D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



D4095-051 WEARPAD ASSEMBLY

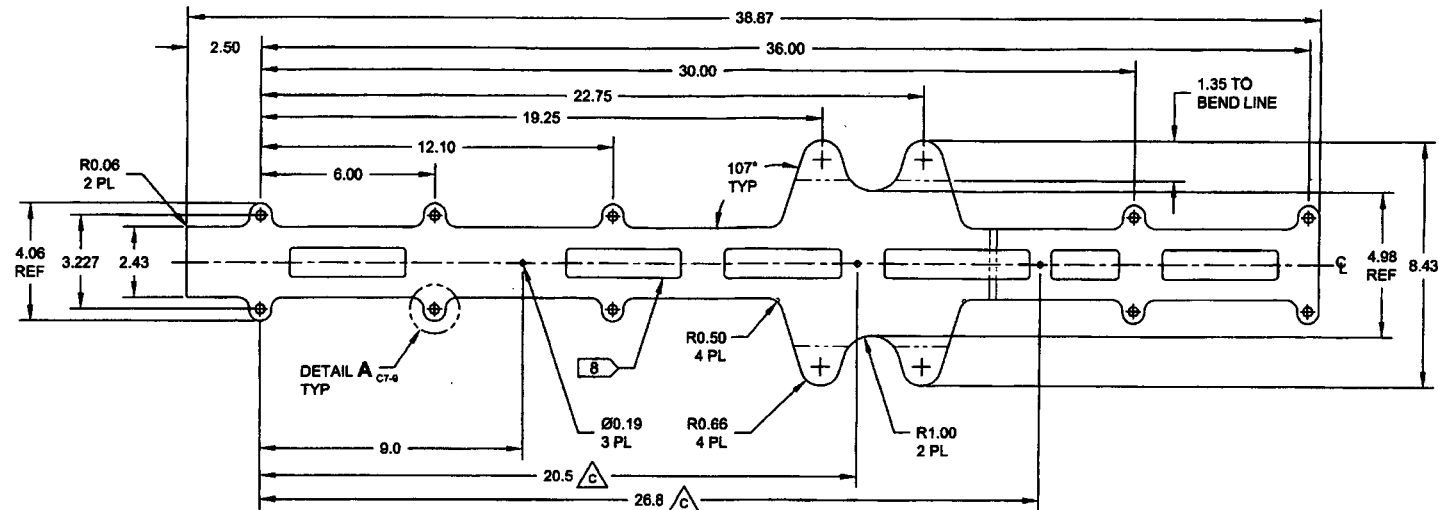
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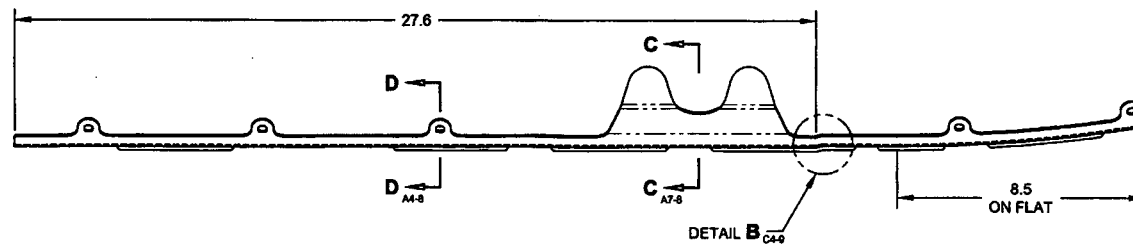
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D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

D4095-3 NOTES:

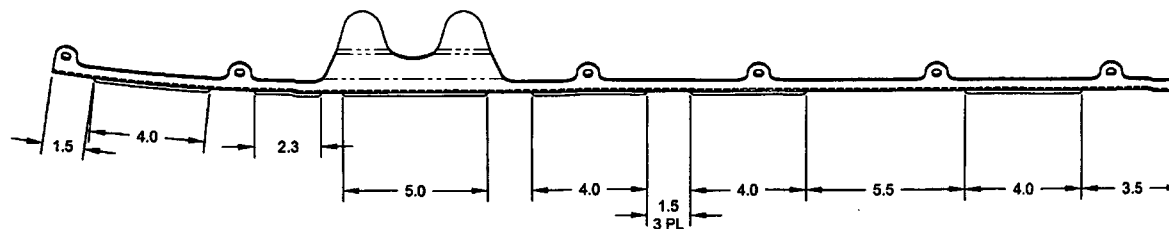
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

UNDER REVIEW

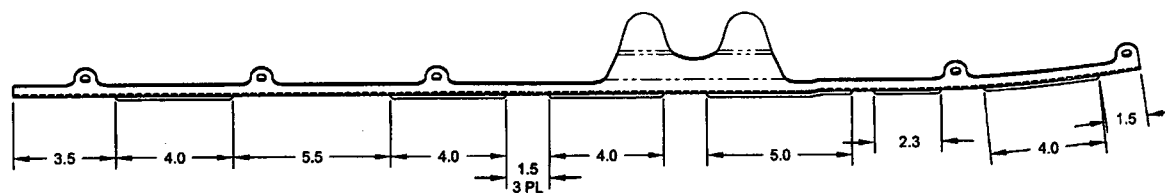
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D4095-1 WELDING DETAIL



D4095-3 WELDING DETAIL

UNDER REVIEW

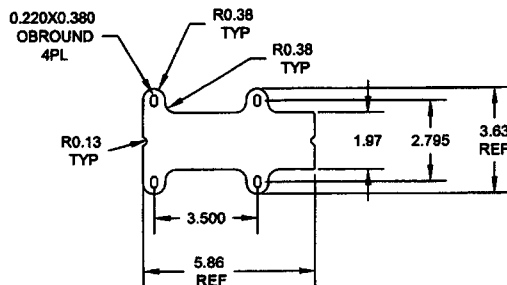
URF 16-572 ML

16.05.03

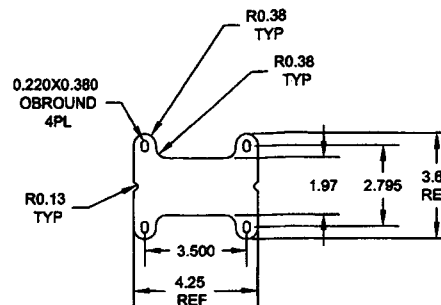
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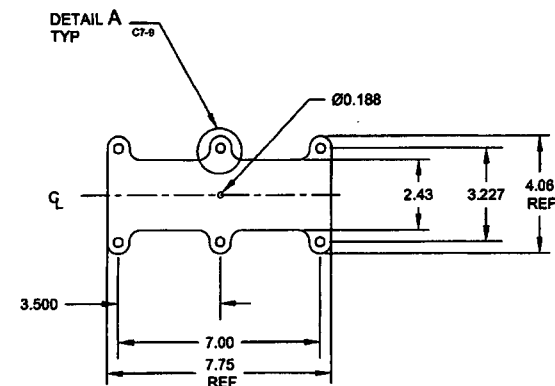
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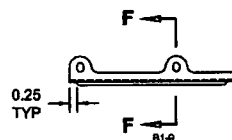
D4095-7F FLAT PATTERN 1



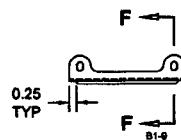
D4095-9F FLAT PATTERN 1



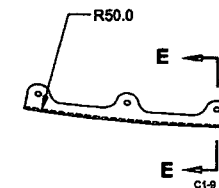
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

D4095-7/-9/-11 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240
OR ASME SA240 REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

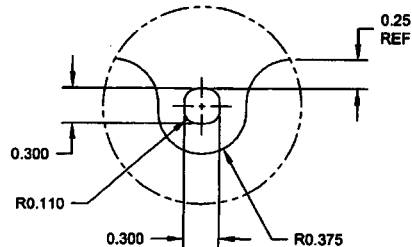
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URF 16-572 ML
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DATE	16.01.06	

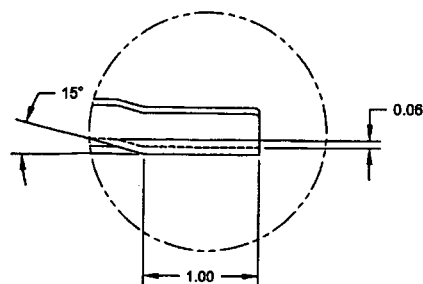
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DETAIL A: TAB DETAIL

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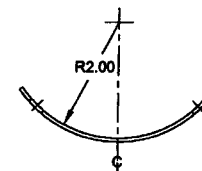
C3-3
C2-6
D3-7
D2-6



DETAIL B: JOGGLE DETAIL

SCALE 4X

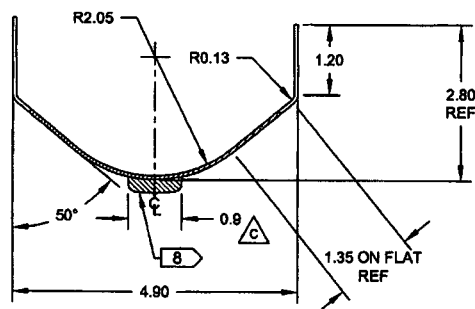
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B6-4
B3-6
B2-7



SECTION E-E

SCALE 2X

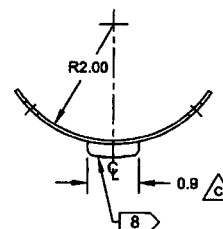
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B2-8



SECTION C-C

SCALE 2X

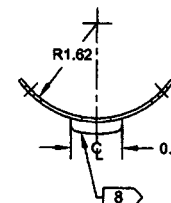
B5-4
B4-5



SECTION D-D

SCALE 2X

B4-4
B5-5



SECTION F-F

SCALE 2X

B5-6
B1-8

UNDER REVIEW

URF 16-572 ML
16.05.03

RELEASE
2016-01-11

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